

669-03

Dart Aerospace Ltd.

Date: Thursday, 05/02/2009 3:46:15 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> : COBRA SKIDTUBE ASS'Y
<b>Job Number</b> : 45552A	
<b>Estimate Number</b> : 13181	
<b>P.O. Number</b> :	<b>Part Number</b> : D209669043
<b>This Issue</b> : 05/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2906 REV.B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 43593A	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 03/03/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.02.06</u>	
<b>Comment</b> : new est. 08.02.13 LL, verified by: DD	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy D209-669 bluefile &amp; type labels per PPP D205-669-041 chg 002

N/A HJ

2.0

D25001190

Ext'n -1" Beam Tube 4"

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B-40150

AWM 9-2-6 (1)

3.0

D29263

Web

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

batch

B 45590

D

M

9-2-9

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1

**Comment:** LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2906 if necessary Deburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

AWM 9-2-6 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 45552A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

① H 9-2-E

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT8149, DT8711-2 & DT8711-3 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2906 without cutting fluid

3-Countersink holes as per Dwg D2906 without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

A/R	Sikaflex-291	5109383	
-----	--------------	---------	--

Sikaflex expire date: 9-12-11

Start Time: 8:30 AM Date: 9-2-9

Fin Time: 11 AM Date: 9-2-11

pick:

Qty	P/N	description	B/N
1	D2926-3	Web	B 45520

- AWM/11  
9-2-9

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program COB41FWD & COBRAFT on CNC Bender and Folio FT

2-Cut tubes as per Dwg. D2906 & per template DT8185B & DT8185BC

DP 9-2-11

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tube as per dwg and ensure ends are perpendicular to ridge

BE 09/02/11

1-Deburr ends

BE 09/02/11

2-Prepare tube for welding, remove alodine as required.

BE 09/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45552A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/11 (X)

10.0

D2579

Crossbolt Spacer



Comment: Qty.: 19.0000 Each(s)/Unit Total: 19.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
19	D2579	Spacers	B413751

19 7-2-10

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld crossbolt spacers D2579 as per Dwg. D2906 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M110295

BE 09/02/11

2-Grind welds as per Dwg D2906 Grind flush ridge made from bending

3-Drill holes for wearplates using DT8217 Open holes to 19/64", adjust stopper not to hit web. Debur

4-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2906, Debur holes

5-Drill pilot holes for aft & fwd cap using DT8215 open holes to #6" Debur

6-Drill pilot holes for Tow ring using DT8091-3 , open to .640" and Debur

BE 09/02/12

12.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

Jos. 02.13 (X)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jos. 02.13 (X)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45552A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Pressure wash as per QSI 005

BL 09-02-17

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 109996

START TIME: 11:00am  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 11:30am

JSJ 09-02-18

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/18

17.0

D2855

Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Cap  
Batch: B42343

FL

18.0

AN35A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Bolt  
Batch: m 100188

FL

19.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
Washer  
Batch: m 109632

FL

20.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)  
Insert  
OR PER QSI 017  
Batch: m 108606

FL 09/02/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45552A

Part Number: D209669043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)  
BOLT  
Batch: 110523

FL

22.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)  
washer  
Batch: m/10023

FL

23.0	D25943	O-Ring, 205 Skidtube
------	--------	----------------------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)  
O-Ring  
Batch: 629908

FL

24.0	D25941	Plug, 205 Skidtube
------	--------	--------------------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)  
Plug  
Batch: 043884

FL

25.0	D35649	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
batch: 044172

FL

26.0	D356411	Wearshoe
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
batch: 044656

FL

27.0	D35645	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
WEARSHOE  
batch: 043893

FL 09/02/18

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45552A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

batch

044173

FL

29.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

batch

044174

FL

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2906. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 m109883

Sikaflex expire date: 09/11

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2906

3-Inspect for foreign object per QSI 024

4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 m109883

Sikaflex expire date: 09/11

5-Wing Walk as per Dwg D2906 and QSI 005 4.4

Batch: m110454

FL 09/02/18 ①

FL 09/02/19 ①

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to current Step Inspect for Foreign objects per QSI 024

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D209-669-041

Location:

PPP Rev:

AP

40552

9/3/19

②

SP

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: COBRA SKIDTUBE ASS'Y

Job Number: 45552A

Part Number: D209669043

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/14 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.06.14

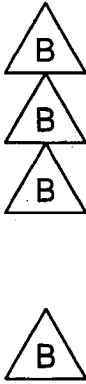
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
1		D3564-15	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1		D3566-15	GASKET
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3C4A	BOLT
4	4	AN3-5A	BOLT
50	44	AN960C10L	WASHER
4	4	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
- 10) ALL DIMENSIONS ARE IN INCHES.

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 155524

**RELEASED**

07.09.04

B	UPDATE DRAWING FORMAT; RE-ORGANIZE; ADD STAINLESS STEEL WEARPLATES AND GASKETS CHANGE WEARPLATE HARDWARE TO SS; PG 1: ADD NOTE 10; PG 2 C7: REMOVE AFT $\varnothing 0.640$ HOLE FROM -041; PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	CB	07.08.21
A	NEW ISSUE	CP	04.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>qp</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>C.B.</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>21</i>	D2906	SHEET 1 OF 3
APPROVED	<i>qp</i>	TITLE	SCALE
DE APPR.	<i>qp</i>	AH-1 (209) SKIDTUBE ASSEMBLY	NTS
DATE	07.08.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

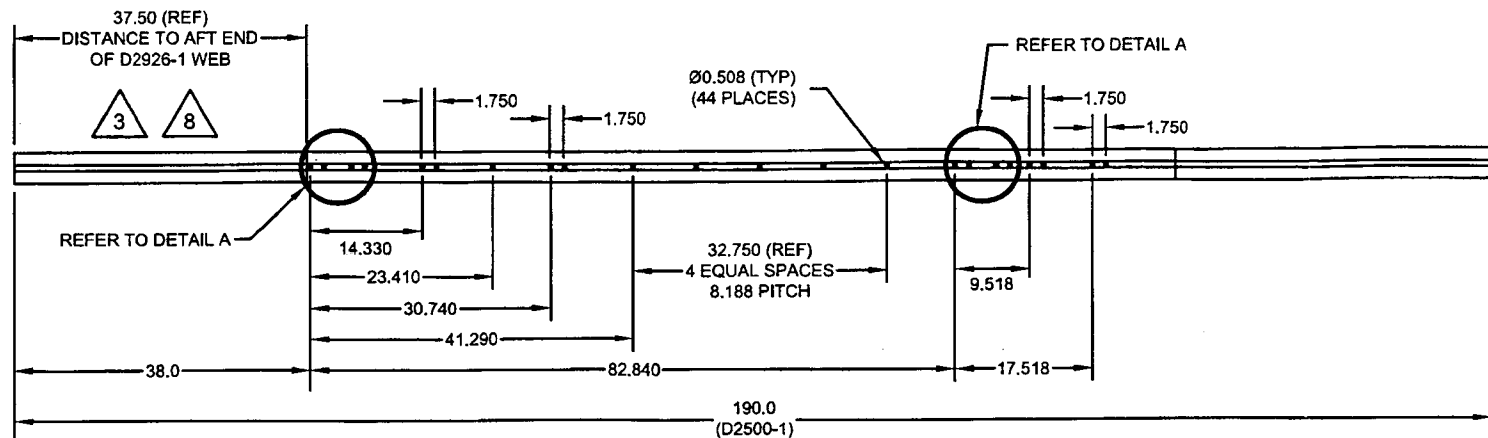
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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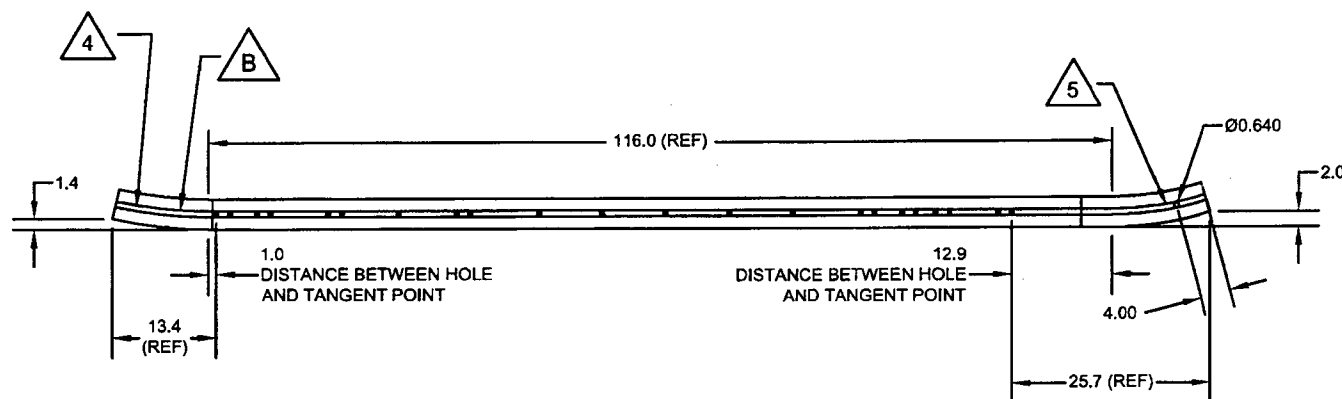
**NOTE:** Date & initial all entries



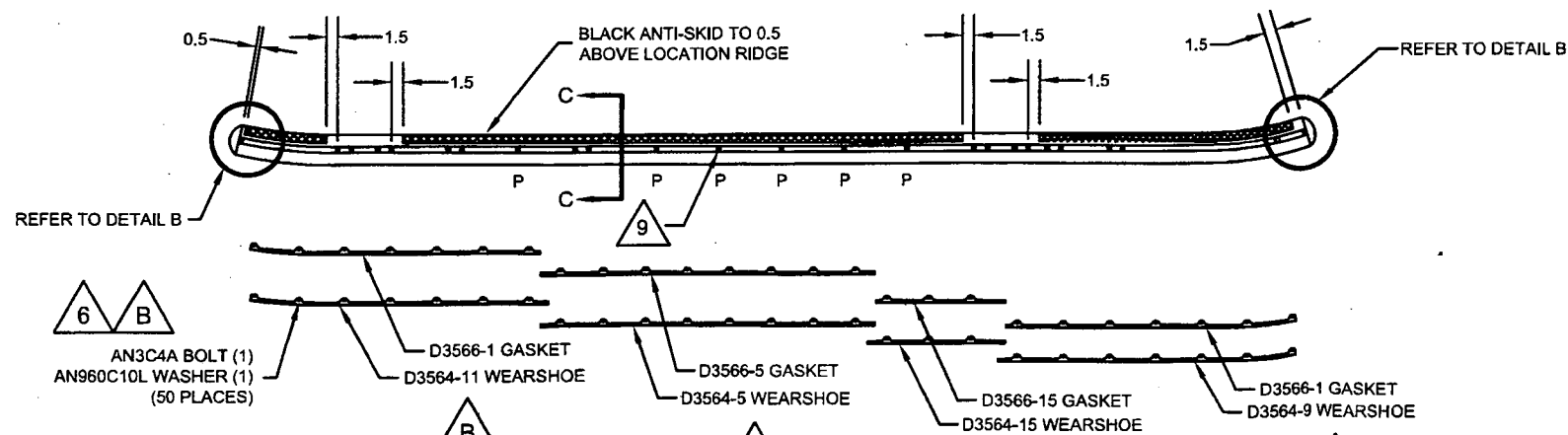
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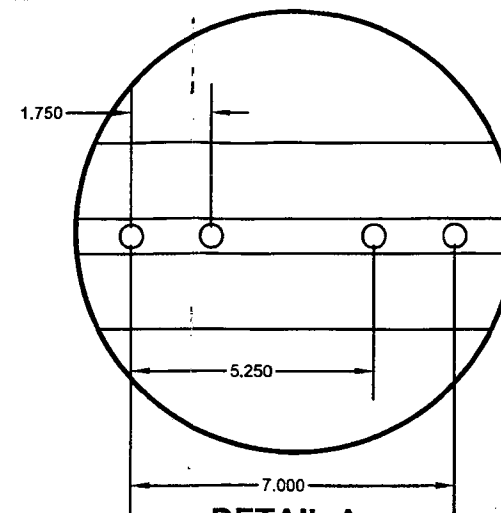
**D2906-1 DRILLING DETAIL**



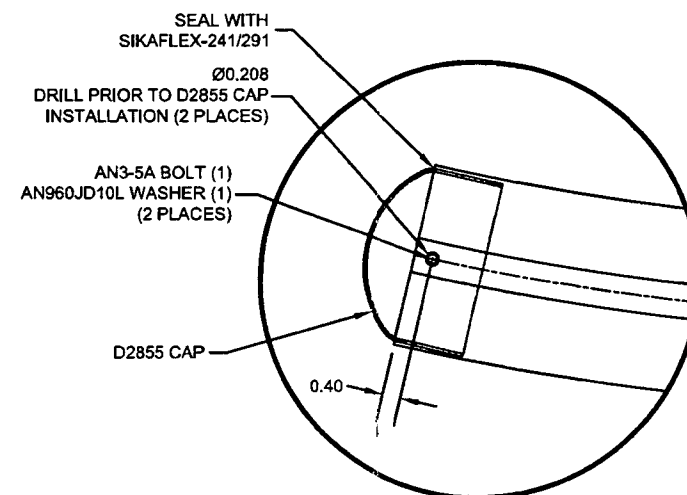
**D2906-041 BENDING AND CUTTING DETAIL**



**D2906-041 ASSEMBLY DETAIL**



**DETAIL A**  
SCALE 1:4

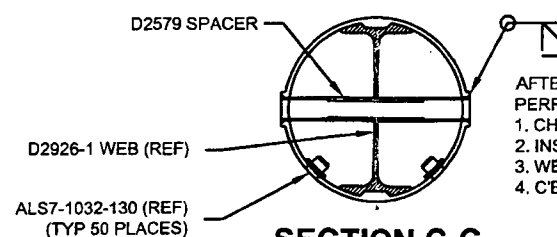


**DETAIL B**  
SCALE 1:4

SHOP COPY  
REFER TO  
ENGINEERING  
UNCONTROLLED COPY  
S. BLT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 15550A

RELEASED

07.09.04



**SECTION C-C**  
SCALE 1:4

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (22 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

DESIGN	9P	<b>DART AEROSPACE LTD</b>	
DRAWN	C.B.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	21	D2906	SHEET 2 OF 3
APPROVED	40	TITLE	SCALE
DE APPR.	10	AH-1 (209) SKIDTUBE ASSEMBLY	1:24
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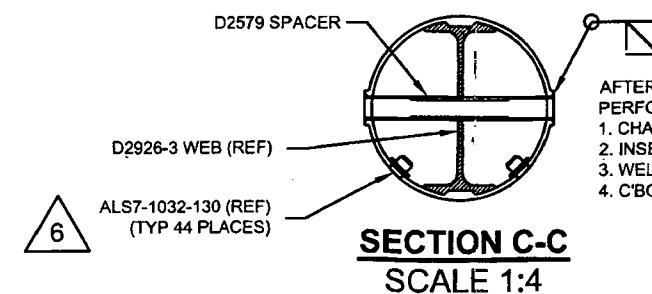




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